

Date: Thursday, 3/30/2006 8:34:42 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 412 WEB
Job Number	: 26437		
Estimate Number	: 10466		
P.O. Number	: N/A	Part Number	: D33891
This Issue	: 3/30/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3389 REV C
First Issue	: N/A	Project Number	: N/A
Previous Run	: 24886	Drawing Revision	: C
		Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 4/20/2006
Checked & Approved By	: <u>SEE ABOVE USPC & DATE</u>	Qty:	1 Um: Each
Comment	: Est Rev:A 05.08.31 New issue KJ/JLM : Est Rev:B 06-02-08 As per Rev C JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25003100	Ext'n -I' Beam Web 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Ext'n -I' Beam Web 4"

Pick:

Qty	Part Number	Description	Batch
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1	D2500-3-100	Web Extrusion	
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B19074 Pm' 06-04-03 (1)

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut to length as per Dwg D3389

2-Drill pilot holes using DT8785 as per Dwg D3389

3-Open 1X .257" Dia Hole

4-Open Remaining holes to finish size as per Dwg D3389

5-Deburr

Pm' 06-04-03 (1)

Pm' 06-04-03 (1)

Pm' 06-04-03 (1)

Pm' 06-04-03 (1)

Pm' 06-04-03 (1)

3.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

BE 06-04-03 (1)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m

06 04 04

(1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: Date: 06/04/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/30/2006 8:34:42 AM
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Drawing Name: 412 WEB

Job Number: 26437

Part Number: D33891

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/04/05 (1)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 4/6

DP 06-4-6

(1)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/10 (1)

Job Completion



u 06/04/07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

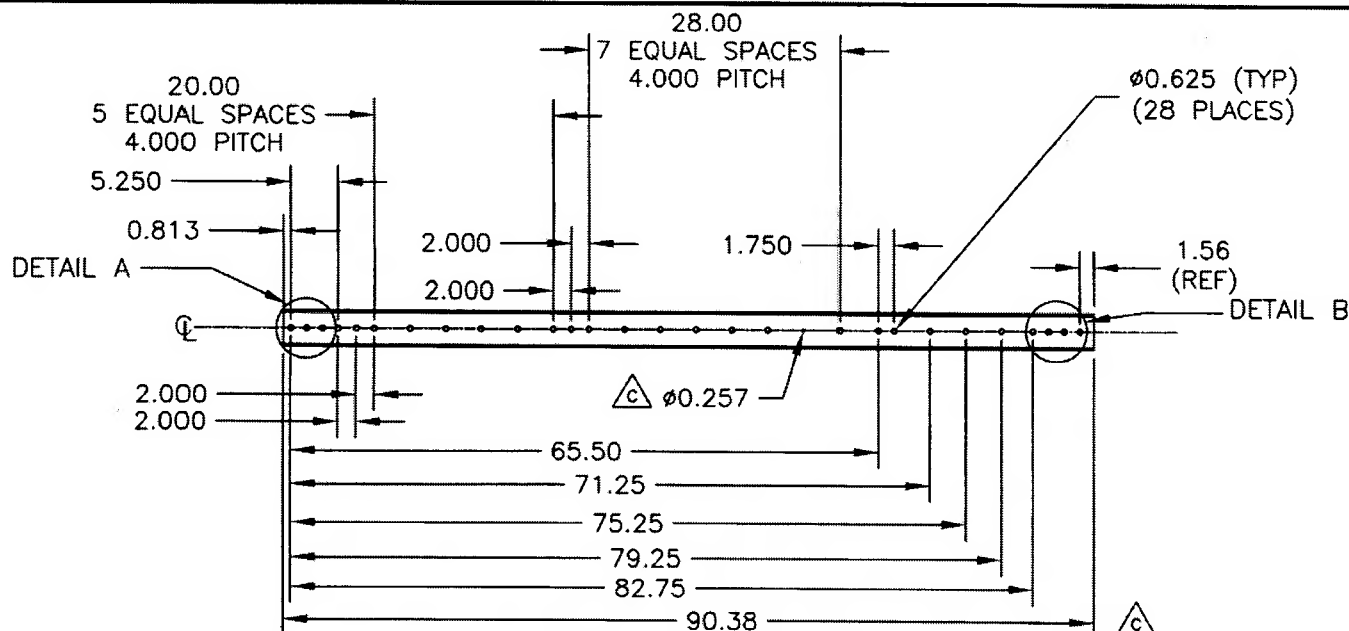
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

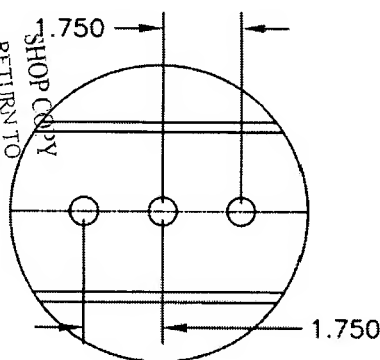
DART

RELEASE
06.01.23

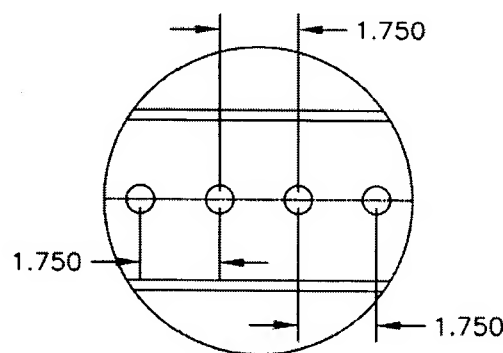
DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	REV. C
CHECKED		APPROVED		DRAWING NO.		SHEET 1 OF 1
DATE				TITLE		SCALE
06.01.23				412 WEB		1:20
A		05.02.07		NEW ISSUE		
B		05.06.13		UPDATE DIMENSIONING		
C		06.01.23		DECREASE OVERALL LENGTH, MODIFY HOLE		



D3389-1 DRILLING DETAIL



DETAIL A
(SCALE 1:4)



DETAIL B
(SCALE 1:4)

D3389-1 412 WEB

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26437

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